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S160306

008507

**D5522-041**  
**Job Sheet 188578**



**Part No:** D5522-041

**Job Qty:** 4 ea

**Part Name:** Oil Drain Valve Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 1/11/19

**Job Tracking No:**

**Due Date:** 2/28/19

**Created By:** Jesse White

**Type:** SOLD

**Description:**

**Note:** D5522 REV.C IPP rev:A RQ 17.04.12 Verified by: DD IPP REV:B 17.05.12 AS PER DWG REV.A DD VERF:JFS IPP REV:C 17.09.19 AS PER DWG REV.C DD VERF:JFS IPP REV:D 17.11.17 MODIFY PROCESS AND BOM AS PER INTUITIVE DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |  | Lead Time | DAS Sign-off        |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|--|-----------|---------------------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier |  |           |                     |
| 90    | Start up Operation | 4 Ea  |            | 2/28/19  | 0.00      | 0.00    | Start Up Small Fab-4  |  |           | 58 MAR 06 2019      |
| 140   | Small Fab          | 4 pcs |            | 2/28/19  | 0.00      | 4.75    | Small Fab-4           |  |           | 9-89 Sm MAR 07 2019 |
| 150   | QC                 | 4 pcs |            | 2/28/19  | 0.00      | 0.00    | QC5                   |  |           | 68 MAR 07 2019      |
| 160   | Packaging          | 4 pcs |            | 2/28/19  | 0.00      | 0.00    | Packaging3-2          |  |           | 9-89 MAR 07 2019    |
| 170   | QC21-SA            | 4 Ea  |            | 2/28/19  | 0.00      | 0.00    | QC21                  |  |           | 21 MAR 07 2019      |

Part Op 140 - \*\*\*BEFORE ASSEMBLY VERIFY IF THE PART IS CLEAN INSIDE\*\*\* Assemble D5522-041 as per Dwg D5522, Descriptions: note 8-9-10,11,12. \*\*\* 1- INSTALL D5527-1 AS PER DWG WITH PERMATEX THREAD SEALANT. TORQUE AS PER DWG NOTE 8. BATCH: M13795 VERIFY TORQUE BY: M13795 Sm \*\*\*BEFORE INSTALLING AN814-4J PLUG AND D5530-1 FITTING REMOVE ORINGS (SCRAP THEM) AND REPLACE THEM WITH M83248/1-012 PACKING\*\*\*\*\* 2- INSTALL AN814-4J PLUG, D5370-1 AND D5530-1 FITTING AS PER DWG WITH OIL LUB 2380. TORQUE AS PER DWG NOTE 9. 2380 BATCH: M13806 VERIFY TORQUE BY: Sm 3- LOCKWIRE AS PER DWG, SEE NOTE 10. 4- ATTACH VALVE CAP WITH LANDYARD AS PER DWG NOTE 11. (PICK CBL460 AND CBL1240)

### Job BOM

| Part / Item  | Component Name          | Quantity     | Operation             | Container         |
|--------------|-------------------------|--------------|-----------------------|-------------------|
| AN814-4JL    | Plug                    | 4 Ea (1 ea)  | 90-Start up Operation | 5060603           |
| CBL-1240     | Cable                   | 4 ft (1 ea)  | 90-Start up Operation | 5113791           |
| CBL-460      | Loop Sleeve             | 16 Ea (4 ea) | 90-Start up Operation | 5148607           |
| D5522-1      | Oil Drain Valve Mount   | 4 Ea (1 ea)  | 90-Start up Operation | 5148607           |
| D5527-1      | Oil Drain Valve         | 8 pcs (2 ea) | 90-Start up Operation | 5147336           |
| D5530-1      | 37° Flared Tube Fitting | 4 pcs (1 ea) | 90-Start up Operation | 5059559           |
| D5532-041    | Valve Cap Assembly      | 8 pcs (2 ea) | 90-Start up Operation | 5145371           |
| M83248/1-012 | Packing                 | 8 Ea (2 ea)  | 90-Start up Operation | 5087815 (M137710) |
| AS3208-06    | Packing                 | 4 Ea (1 ea)  | 90-Start up Operation | 5001689           |
| D5370-1      | Fitting                 | 4 pcs (1 ea) | 90-Start up Operation | 5145007           |



| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 90-Start up Operation              | AN814-4JL      | 4        | 17        | 0         |
|                                    | AS3208-06      | 4        | 152       | 0         |
|                                    | CBL-1240       | 4        | 207       | 0         |
|                                    | CBL-460        | 16       | 358       | 0         |
|                                    | D5370-1        | 4        | 22        | 0         |
|                                    | D5522-1        | 4        | 0         | 0         |
|                                    | D5527-1        | 8        | 6         | 0         |
|                                    | D5530-1        | 4        | 10        | 0         |
|                                    | D5532-041      | 8        | 8         | 0         |
|                                    | M83248/1-012   | 8        | 102       | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

Plex 1/11/19 9:08 AM dart.white.jesse



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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height: 200px;"> <span style="color: red; font-size: 2em; transform: rotate(-45deg); display: inline-block;">50514619348</span> <div style="position: absolute; right: 0; top: 0;"> </div> </div>                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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| <b>Root Cause</b><br><table style="width:100%;"> <tr> <td style="width:50%;">           Environment <input type="checkbox"/><br/>           Design <input type="checkbox"/><br/>           Doc/Data <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Pre <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Internal Transport <input type="checkbox"/><br/>           Tribal Knowledge <input type="checkbox"/><br/>           LOA <input type="checkbox"/><br/>           Substation <input type="checkbox"/><br/>           Past Expiry Date <input type="checkbox"/><br/>           Misidentified <input type="checkbox"/> </td> <td style="width:50%;">           No Re-verification <input type="checkbox"/><br/>           Operator <input type="checkbox"/><br/>           Offset/Setup <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Training <input type="checkbox"/><br/>           Use for Testing <input type="checkbox"/><br/>           Poor Information <input type="checkbox"/><br/>           Rushing <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Past Due <input type="checkbox"/> </td> </tr> </table> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input 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Incomplete/Unclear <input type="checkbox"/><br/>           Drill Holes <input type="checkbox"/> </td> </tr> </table> |  | Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input 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